

# Work Order ID 101306

\*101306\*

Tuesday, May 07, 2013 2:30:52 PM

Ship tomorrow Page 1

Item ID: E4615-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Blanking Plate  
 Start Date: 5/7/2013 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 5/8/2013 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: MF Date: 5-5-13 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
E4615	A								

100 0.00  
 \*100\* FLOW WATER JET 4 0 Jm13-5-7  
 Waterjet Memo 0.00

FLOW CNC Waterjet  
 6061.063  
 \*\*\*\*SEE ( P.E.C. ) FOR MORE DETAIL\*\*\*\*  
 1-Cut as per Dwg  
 Dwg Rev: A  
 Prog Rev: A  
 \*\*\*\*MARK HOLE CENTER USING WATERJET WITHOUT ABRASIVE\*\*\*\* ✓  
 2- Deburr if necessary

110 0.00  
 \*110\* QC2- Inspect parts off machine FAI/FAIB 4 0 Jm13-5-7  
 QC Memo 0.00  
 Quality Control

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Item ID: E4615-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Blanking Plate  
Start Date: 5/7/2013      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 5/8/2013      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00 13.58				4			
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00 13.58				4			
140 <b>*140*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00 13.58				4			

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Item ID: E4615-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Blanking Plate  
 Start Date: 5/7/2013 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 5/8/2013 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*MF*  
13-5-8

*ML5* 13-05-08

*MF*  
13-5-8

# Picklist Print

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Work Order ID: 101306

Parent Item: E4615-1

Parent Item Name: Blanking Plate

Start Date: 5/7/2013

Required Date: 5/8/2013

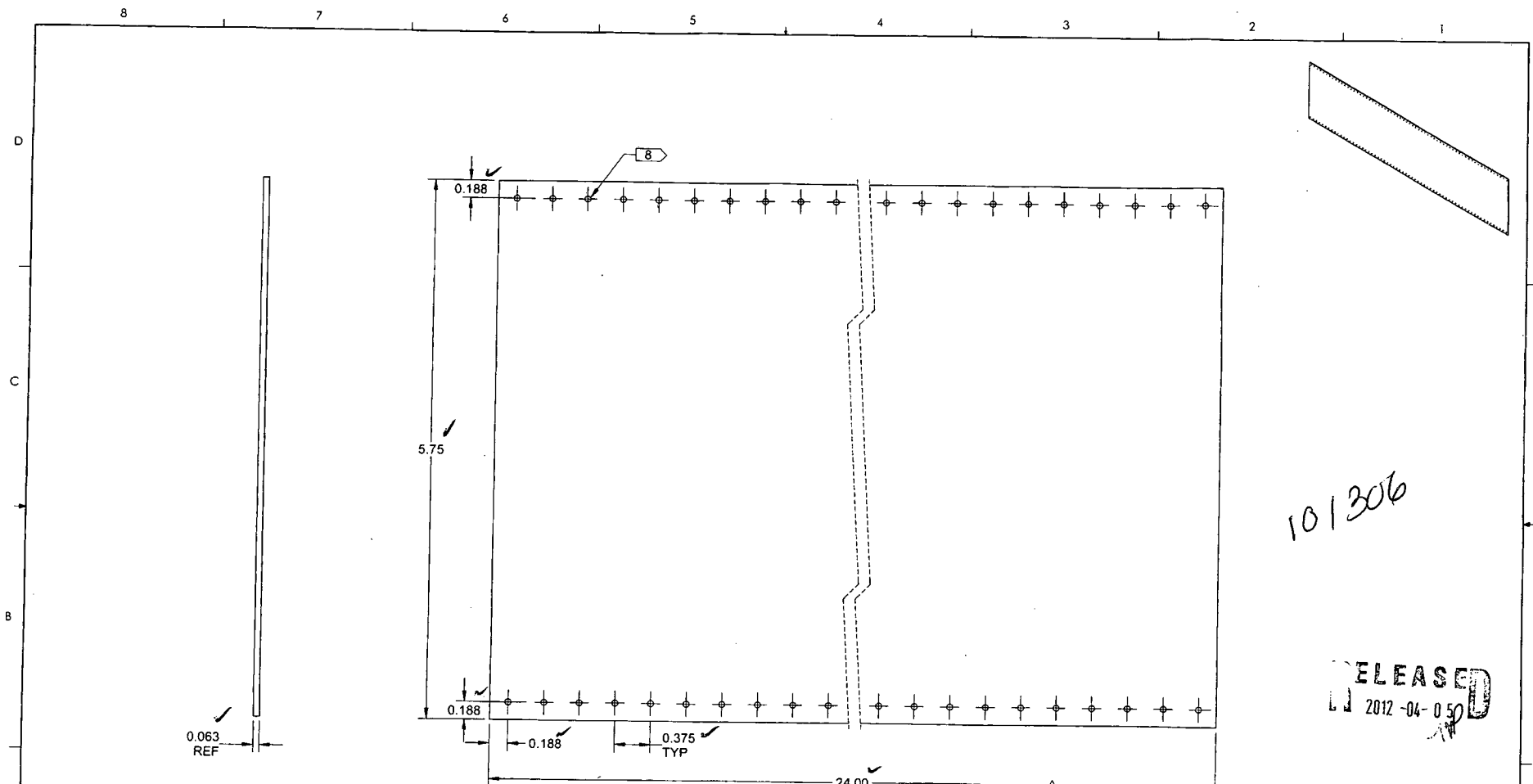
Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	415.3125	0.96	4.0421053 4.1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		415.3125							
				123135		120.5625							
				124003		85							
				125431		209.75							
										124003			

Jm 3-5-7



101306

RELEASED  
2012-04-05

# **E4615-1 BLANKING PLATE**

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.85 lbs
  - 8) MARK HOLE CENTER USING WATERJET WITHOUT ABRASIVE

A		NEW ISSUE		12.03.05	
REV.		DESCRIPTION		BY	DATE
DESIGN		<b>EAGLE COPTERS LTD</b> CALGARY, ALBERTA, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		E4615		SHEET 1 OF 1	
APPROVED	N/A	TITLE		SCALE	
DE APPR.	N/A	BLANKING PLATE		NTS	
DATE	12.03.05	COPYRIGHT © 2012 BY EAGLE COPTERS LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.</small>			

